

Must ship 06/09/15 or 18

Dart Aerospace Ltd.

Date: Wednesday, 15/09/2006 8:59:19 AM
User: COSS Admin

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR ARM LONG (S-76)
Job Number : 28495	
Estimate Number : 11893	
P.O. Number : <i>N/A</i>	Part Number : D2261
This Issue : 13/09/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2261 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : _____	Due Date : 18/09/2006 Qty: 1 Um: Each
Checked & Approved By : <i>W</i>	
Comment : Est: D 02.04.15 Added dwg Rev.A1 NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
<div>Comment: Qty.: 3.1281 f(s)/Unit Total : 3.1281 f(s) Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall (M304TR0500W035) Batch No: <i>11 101593</i> <i>FF 06.09.13</i></div>		
2.0	BRAKE NC	NC BRAKE
<div>Comment: BRAKE NC Punch tube 304/316 with 2B finish Form as per dwg D2261 Deburr <i>FF 06.09.13</i></div>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
<div>Comment: INSPECT WORK TO CURRENT STEP <i>SB 06/09/13</i> (1)</div>		
4.0	POWDER COATING	POWDER COATING
<div>Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 <i>FL 06 09 13</i> (1)</div>		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
<div>Comment: INSPECT POWDER COAT <i>SB 06/09/14</i> (1)</div>		

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/09/2006 8:59:20 AM
User: COSS Admin

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM LONG (S-76)

Job Number: 28495

Part Number: D2261

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2022101	Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
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4	D2022-101	Spacer	B25815
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FF 06.09.14

7.0	A1449	Grommet
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Grommet

Pick:

Qty	Part Number	Description	Batch
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2	A1449	Grommet	M1487
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FF 06.09.14

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2261

FF 06.09.14

9.0	QC5	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/09/14

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S1372

LB 06/09/15

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

06/09/15

Job Completion



06/09/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

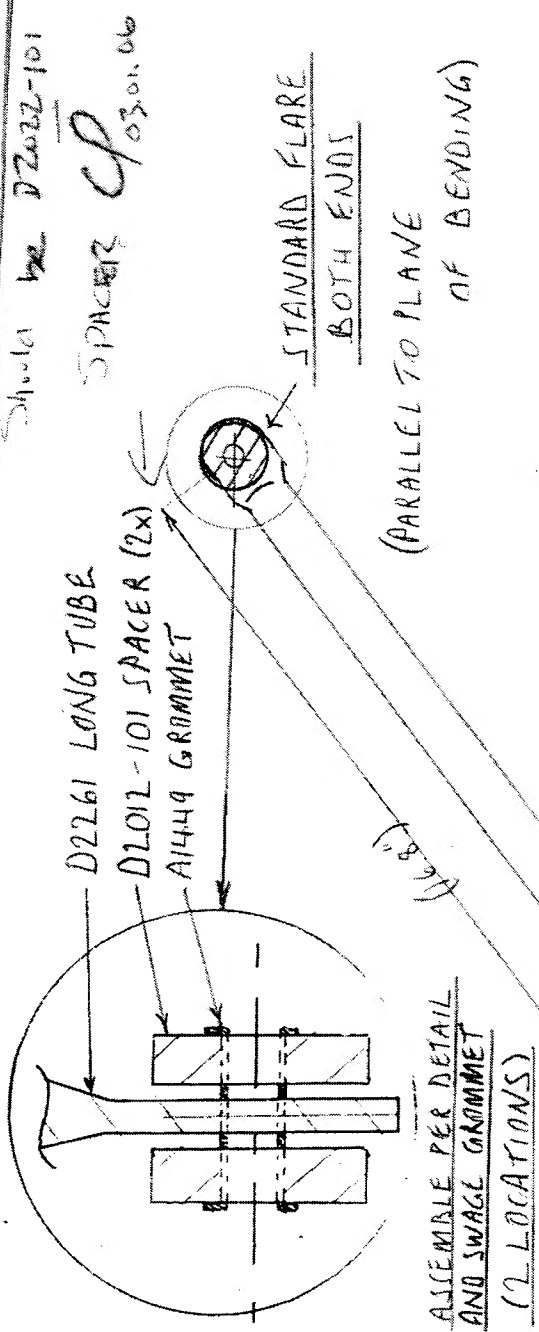
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART

DRAWN <i>M. Cohen.</i>	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA		
DESIGN	DRAWING NO. <i>D22261</i>	REV. <i>A</i>	SHEET 1 OF 1
<i>Aug 10/94</i>	TITLE LONG TUBE		
<i>A1</i>	<i>0203.22</i>	ADD FIN: 5H	

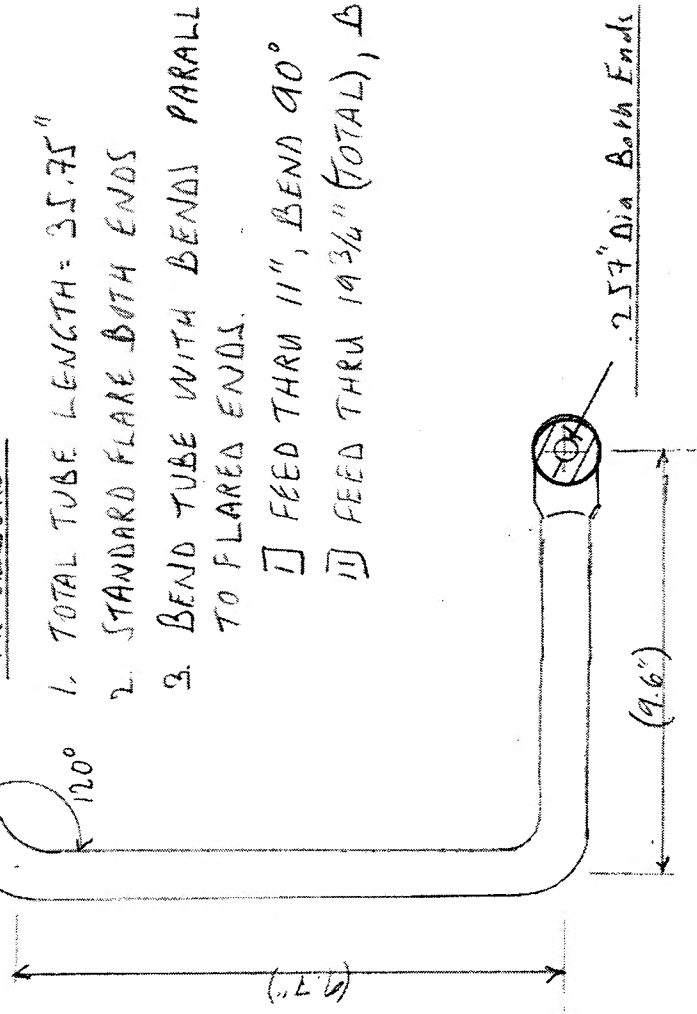


MATL: 304 SS 1/2" OD x .035" WALL TUBE

FINISH: POWDER COAT BLACK SANDTEX (435.7)
PER DART Q31 Q35 4.3 (A1)

PROCEDURE:

1. TOTAL TUBE LENGTH = 35.75"
2. STANDARD FLARE BOTH ENDS
3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS.
 - I] FEED THRU 11", BEND 90°
 - II] FEED THRU 19 3/4" (TOTAL), BEND 60°



REFERENCE ONLY